

ASP

Work Order ID 108532

October-17-13 3:01:55 PM

D 3 5 3 6 - 1 3  
B 1 0 8 5 3 2

\*108532\*

Item ID: D3536-13

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Gasket Fwd

Stop \*NS2\*

Start Date: 10/17/13 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 10/22/13 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals: Process Plan: MW Date: 10-17 Tooling:

Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3536	Rev A								

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 Dwg Rev: A Prog Rev: A 2-  
Deburr if necessary

13

0

Jm13-10-27

no. 063

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

13

0

Jm13-10-27

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

DAS  
27  
9-89

13-10-28

13

# Work Order ID 108532

October-17-13 3:01:55 PM

**\*108532\***

Page 2

Item ID: D3536-13 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Gasket Fwd  
 Start Date: 10/17/13 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 10/22/13 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>FP-001</u>	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

13 x 4 1/2 13 1/10 1/2

*[Handwritten signature]* / *MB-10-30*  
*mf*  
 13-10-29



# Picklist Print

October-17-13 3:01:55 PM

Page 1

Work Order ID: 108532

Parent Item: D3536-13

Parent Item Name: Gasket Fwd

Start Date: 10/17/13

Required Date: 10/22/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 NEOPRENE SHEET 0.063		Purchased	No			100	sf	550.7800	0.8269	<del>10</del> 13			Jm13-10-27
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT052		550.78							
				M126546		550.78			126546				

DART AEROSPACE LTD		Work Order:	108532
Description: Gasket		Part Number:	D3536-13
Inspection Dwg: D3536	Rev: A	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.90	+/-0.030	32.90"	-		T	Jkno6
29.40	+/-0.030	29.40"	-		T	
27.40	+/-0.030	27.40"	-		T	
23.90	+/-0.030	23.90"	-		T	
18.98	+/-0.030	18.98"	-		T	
14.07	+/-0.030	14.07"	-		T	
9.15	+/-0.030	9.15"	-		V	Production
5.65	+/-0.030	5.65"	-		V	Jkmo1
3.90	+/-0.030	3.90"	-		V	
8.00	+/-0.030	8.00"	-		V	
14.00	+/-0.030	14.00"	-		T	
20.00	+/-0.030	20.00"	-		T	
1.89	+/-0.030	1.89"	-		V	
0.30	+/-0.030	0.30"	-		V	
0.30	+/-0.030	0.30"	-		V	
Ø0.19	+0.005/-0.001	0.19"	-		V	

DAS  
27

Measured by: Jm	Audited by: 989	Prototype Approval:	N/A
Date: 13.10.27	Date: 13/10/27	Date:	N/A


Rev	Date	Change	Revised by	Approved
A	07.06.13	New Issue	KJ/JLM	BE

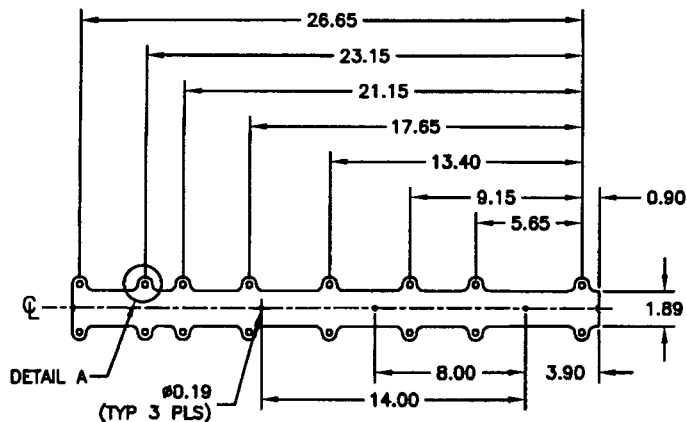
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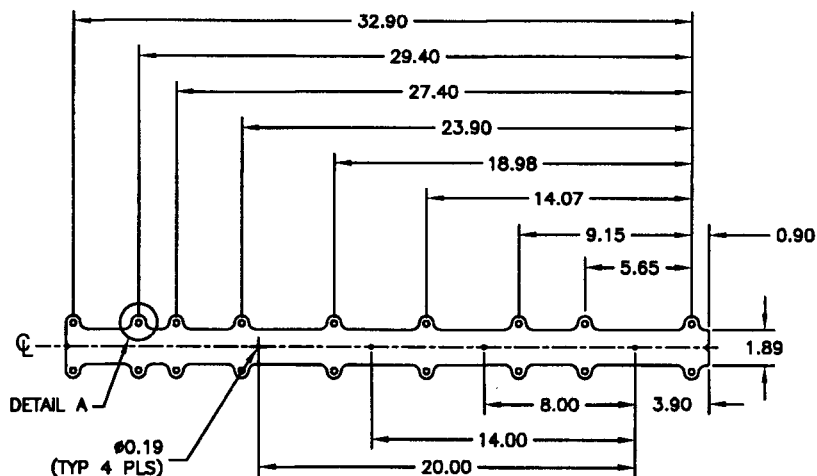
09.02.12-4

108532 MLC  
13-10-17

DESIGN		DRAWN BY	DART AEROSPACE USA, INC.	
CB		CB	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. A	
RH		D3536	SHEET 1 OF 6	
DATE	TITLE		SCALE	
06.10.25	GASKET		1:10	
A	06.10.25	NEW ISSUE		



**D3536-11 GASKET**



**D3536-13 GASKET**

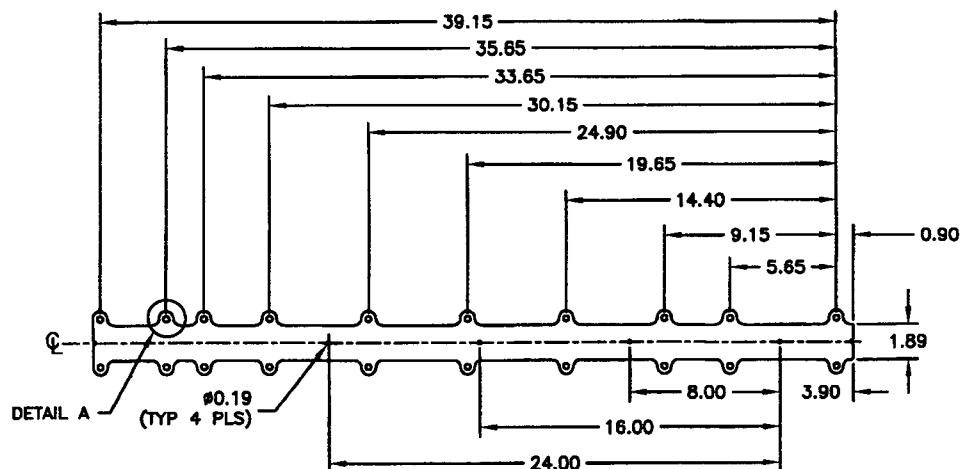
**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

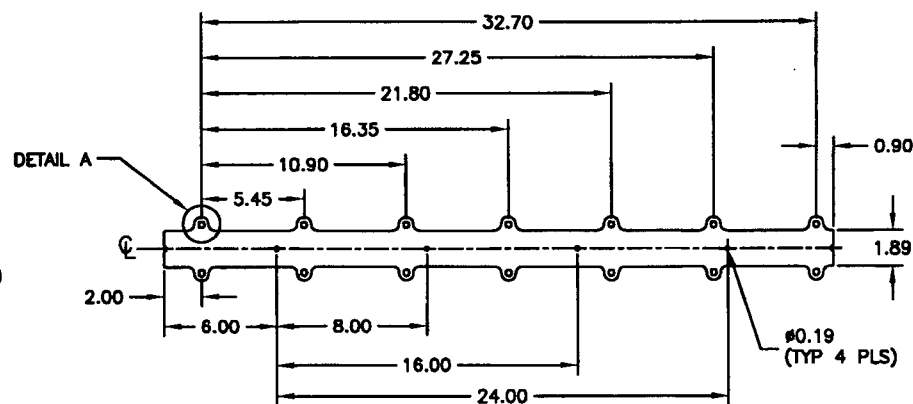
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**D3536-15 GASKET**



**D3536-21 GASKET**

**NOTES**

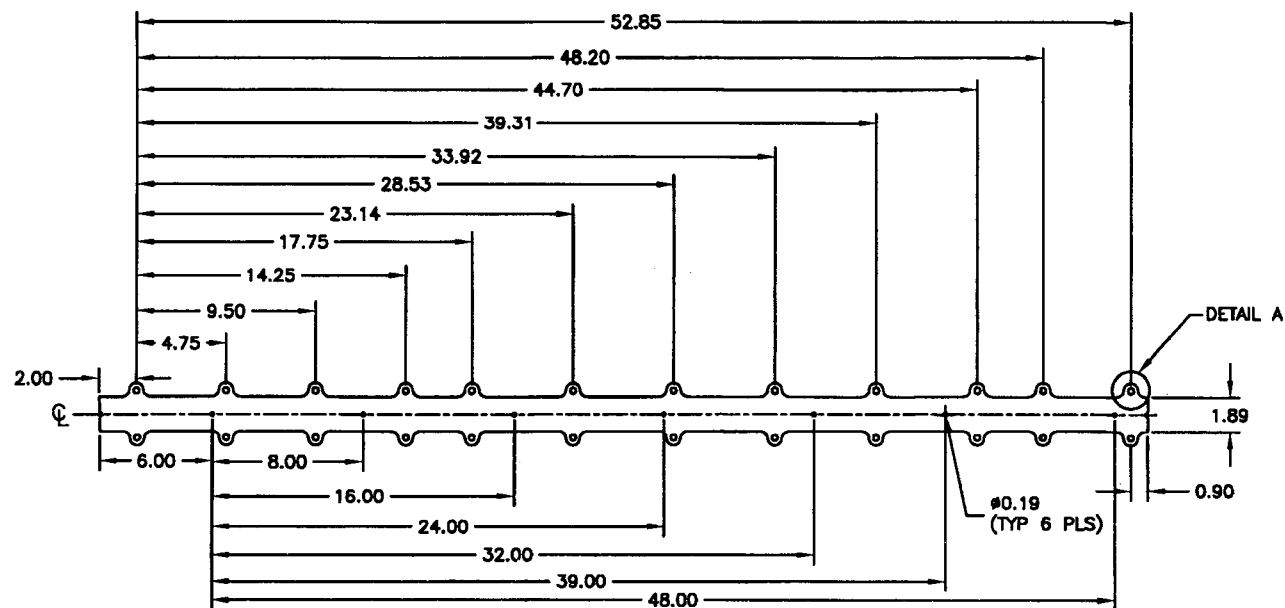
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
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- 5) ALL DIMENSIONS ARE IN INCHES
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				SCALE 1:10

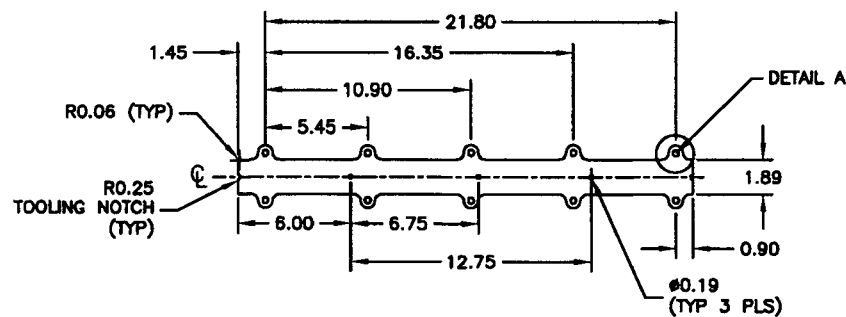
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**D3536-23 GASKET**



**D3536-25 GASKET**

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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		DRAWING NO.	D3536	SHEET 3 OF 6
		SCALE	1:10	

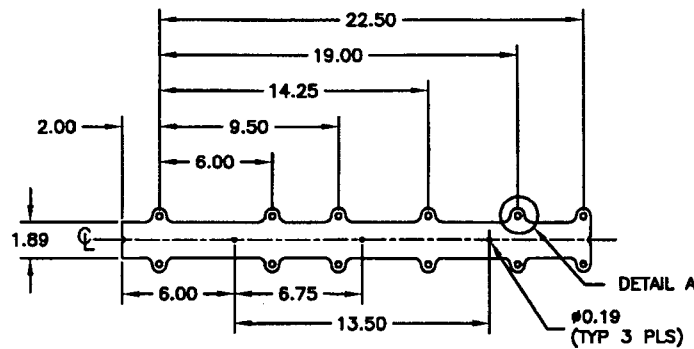




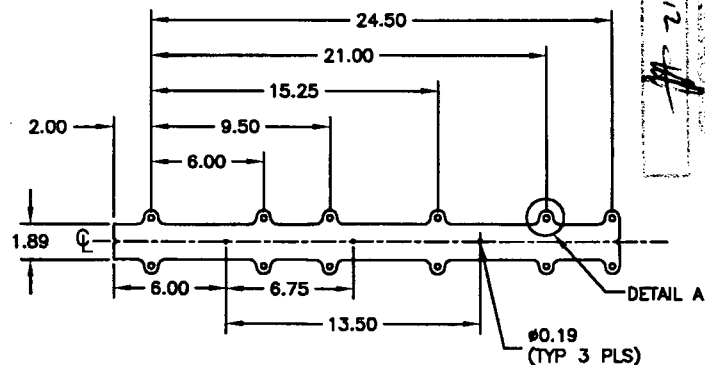
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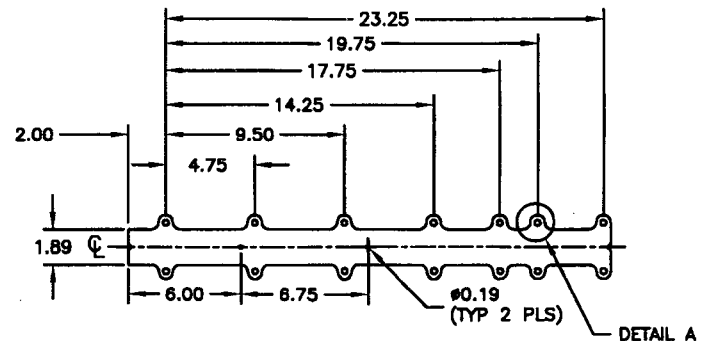
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**D3536-31 GASKET**



**D3536-33 GASKET**



**D3536-35 GASKET**

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

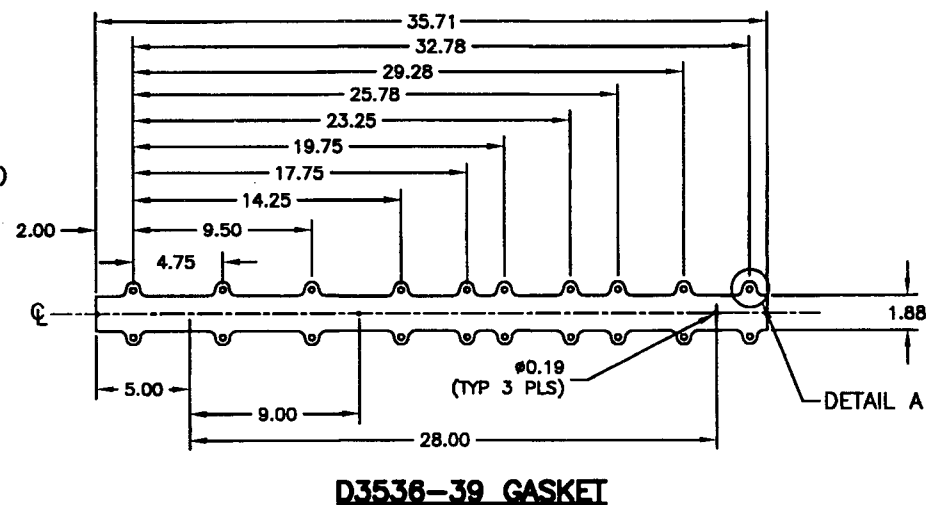
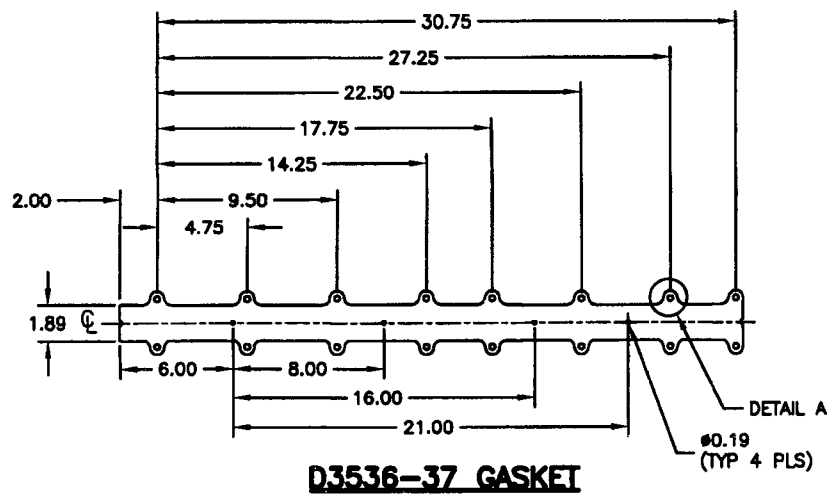
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PH	PH	D3536
DATE	TITLE	REV. A
06.10.25	GASKET	SHEET 4 OF 6
		SCALE 1:10



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**DART**

07.02.02  
H



- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE080-S.063)
  - 2) FINISH: NONE
  - 3) PART IS SYMMETRICAL ABOUT C
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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DATE	06.10.25	TITLE	D3536	REV. A
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				SCALE 1:10

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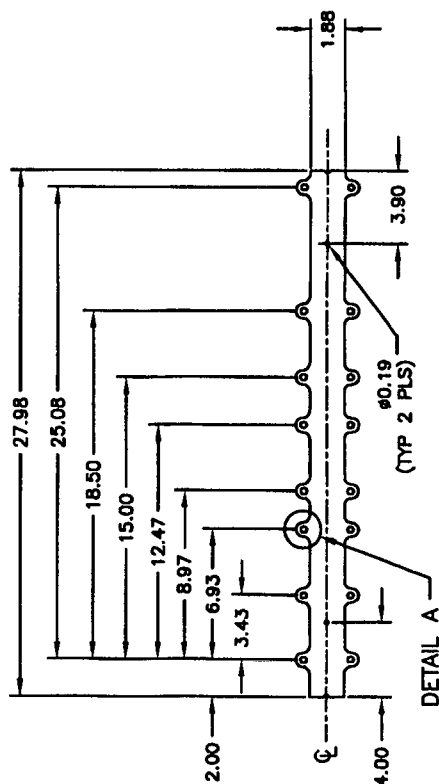
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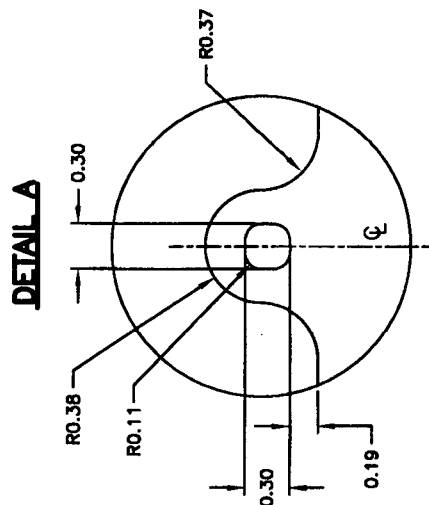


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DATE <b>06.10.25</b>		TITLE <b>GASKET</b>	SCALE <b>1:10</b>

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**D3536-41 GASKET**



- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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  - 3) PART IS SYMMETRICAL ABOUT  $\phi$
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  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

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